

Work Order ID 54573

December 14, 2009 10:43:36 AM



Page 1

Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

Start Date: 14/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

RL

Date:

14/12/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3523

Rev B

NOO SAN

100

0.00



~~Hardinge CNC LATHE SMALL~~

Hardinge

Memo

0.00

14/12/30

6 *0*

Hardinge CNC Lathe Small

Machine as per folio FA702 & dwg D3523

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

14/12/30

6 *0*

Quality Control

120

CONVENTIONAL MILLING MACHINE

0.00



Mill Conv

Memo

0.00

14/12/04

4 *02*

Conventional Milling Machine

Drill For Helicoil & Set-Screw

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3523-3 PAR #: N/A Fault Category: MACH. NCR: Yes No DQA: JA Date: 10.01.20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: JA Date: 10/01/26

NCR: <u>54573</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/01/04</u>	<u>120</u>	<u>2 parts scrap. the hole off center. R.L. the drill deviated during the process by the 2 other holes.</u>	<u>JA</u> <u>07/12</u>	<u>scrap and destroy no replace Qty 42</u>	<u>mf</u> <u>10/01/04</u>	<u>S</u> <u>10/01/13</u>	<u>JA</u> <u>07/12</u>	<u>S</u> <u>10/01/13</u>

NOTE: Date & initial all entries

Work Order ID 54573

December 14, 2009 10:43:37 AM



Page 2

Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

Start Date: 14/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

N/A *Jul 01-05*

Quality Control

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jul 01-05

6 *✓*

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10-06-05

⑥ *✓*

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54573

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Page 3

Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

Start Date: 4/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Mask threaded holes & Ball as per Dwg D3523 START TIME:
OVEN TEMPERATURE: FINISH
TIME:*Abolish only per drawing U**FVO*

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*U 10/10/07**(X4) 8*

180

CONVENTIONAL MILLING MACHINE

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

Install Helicoil as per Dwg D3523

*U 10.10.19**4*

W/O: 54573

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01.05	160	permanent change	E	10.01.19		CE 10.01.19	S 10/01/19

Part No: D3523-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54573

December 14, 2009 10:43:37 AM



Page 4

Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

Start Date: 14/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 8/10/19

74

Quality Control

200

Identify as per dwg & Stock Location: 68

0.00



Packaging

Memo

0.00

10-1-19 (40) SD

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/01/19 JF

Quality Control

MF 10-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 14, 2009 10:43:43 AM

Work Order ID: 54573

Parent Item: D3523-3

Parent Item Name: Leg

Start Date: 14/12/2009

Required Date: 24/12/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg. # Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	-----------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21209-F120		Purchased	No			100	Each	44.0000	6.0000			
--------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



HELI COIL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

44

107823

44

M6061T6R1.000

Purchased

No

180

f

71.3050

0.7326



ROUND BAR 1.00"

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

71.305

108876

8.355

110966

51.55

17887

11.4

113457

x6 up 10.10.19

SA 04/12/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

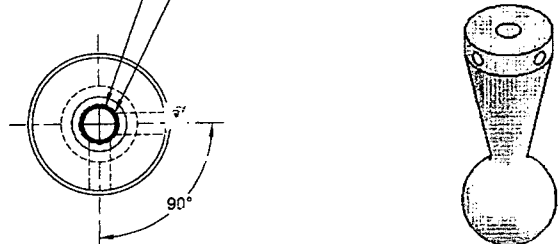
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

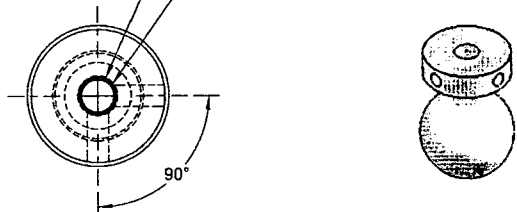
NOTE: Date & initial all entries

DRILL #7 ($\phi 0.201$) x 0.83 DEEP $\triangle B$
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)
INSTALL MS21209-F1-20 HELI-COIL
TO THE BOTTOM OF THE HOLE

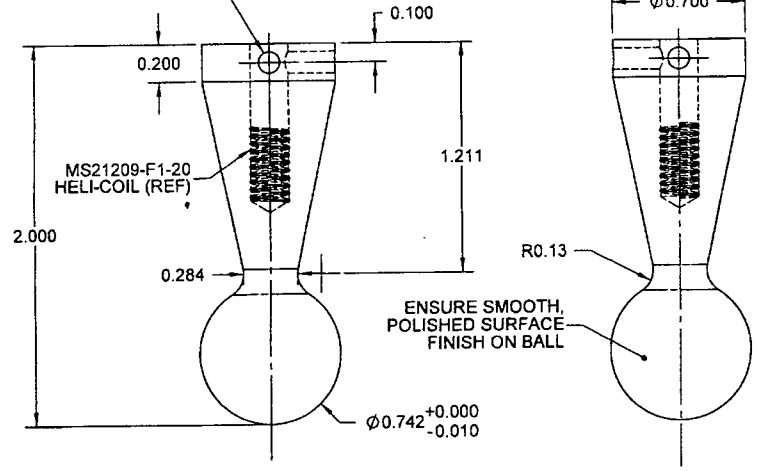


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34573

DRILL #7 ($\phi 0.201$) x 0.83 DEEP $\triangle B$
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)
INSTALL MS21209-F1-20 HELI-COIL
TO THE BOTTOM OF THE HOLE

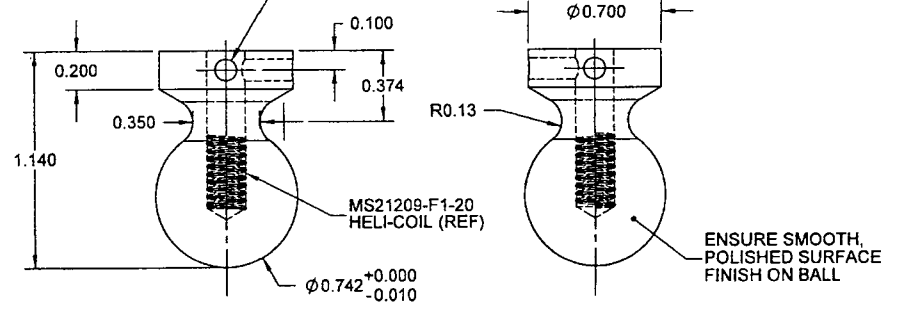


DRILL #33 ($\phi 0.113$)
TAP #6-40 UNF
(2 PLACES)



D3523-1 LEG

DRILL #33 ($\phi 0.113$)
TAP #6-40 UNF
(2 PLACES)



D3523-3 LEG

RELEASED
27-08-03



- NOTES:**
1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3523-1: 0.05 lbs
D3523-3: 0.03 lbs

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES; ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	EE	D3523	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	HH	LEG	3:2
DATE	07.07.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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